

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021312**Date Inspected:** 27-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

Notification no: 008411.

OBG Seg 14W (Deck Panels):

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a UT report on this date. The members are identified as OBG components. The weld designations reviewed are as follows:

- 1) DP3177-001-028, 030, 032, 156, 154, 152.
- 2) DP3175-001-244, 245, 246, 247, 248.

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

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The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3013S-011 (Deck Panel Diaphragm to Floor Beam, complete joint penetration (CJP) weld at panel point (PP) 117.5). The welder is identified as 066419 and was observed welding in 2G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with Welding Procedure Specification (WPS): B-T-2232-ESAB.

The FCAW process on weld joint no: Seg3013B-255 (Deck Panel Diaphragm to Floor Beam, CJP weld at PP120). The welder is identified as 045143 and was observed welding in 2G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: Seg3013G-023 (Deck Panel Diaphragm to Floor Beam, CJP weld at PP119+1500). The welder is identified as 066359 and was observed welding in 2G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: Seg3013AA-109 [Deck Panel (DP) 3116A to Edge Plate (EP) 3020A, fillet weld at PP117.5]. The welder is identified as 067765 and was observed welding in 4F position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

The FCAW process on weld joint no: Seg3013J-008 (Deck Panel Diaphragm to Floor Beam, CJP weld at PP119). The welder is identified as 203871 and was observed welding in 2G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

The SMAW process on weld joint no: Seg3013S-135 (DP3116A to FB3175A, fillet weld at PP117.5). The welder is identified as 067765 and was observed welding in 4G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

OBG Seg 14W:

The FCAW process on weld joint no: Seg3020BB-058 (Bottom Panel to Anchorage Plate, CJP weld). The welder is identified as 045175 and was observed welding in 2G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: B-T-2232-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer